

# Work Order ID 51237

August 12, 2009 8:12:37 AM



Page 1

Item ID: D3063-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 8/12/09 Start Qty: 40.00



Cust Item ID:

Required Date: 8/18/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *09/08/12* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3063

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blanks 4.000" x 2.500" x 0.625" thick

*DIH 09/08/13*

*40*

*Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA175 and Dwg D3063: 12-Deburr & Tumble

*mmf 09/08/10*

*40*

*Ø*

120

0.00



QC2- Inspect parts off machine FA1/FA1B

QC

Memo

0.00

Quality Control

*mmf 09/08/10*

*40*

*Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51237

August 12, 2009 8:12:37 AM



Page 2

Item ID: D3063-1

Accept

Revision ID: A

Item Name: Support

Setup Start

Stop

Start Date: 8/12/09 Start Qty: 40.00

Required Date: 8/18/09 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*mk 09/08/17*

*40*

*PC 9/8/18 (40)*

*09/08/24*

*mf 09-08-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 12, 2009 8:12:37 AM

Page 1 / 1

Work Order ID: 51237

Parent Item: D3063-1RevA

Parent Item Name: Support

Comments:

Start Date: 8/12/09

Required Date: 8/18/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.625X02.50 0		Purchased	No			100	f	23.2000	14.3874			



6061-T6 Bar .625 x 2.50



Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

108961

23.2

23.2

DI 8/13

14.3874

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

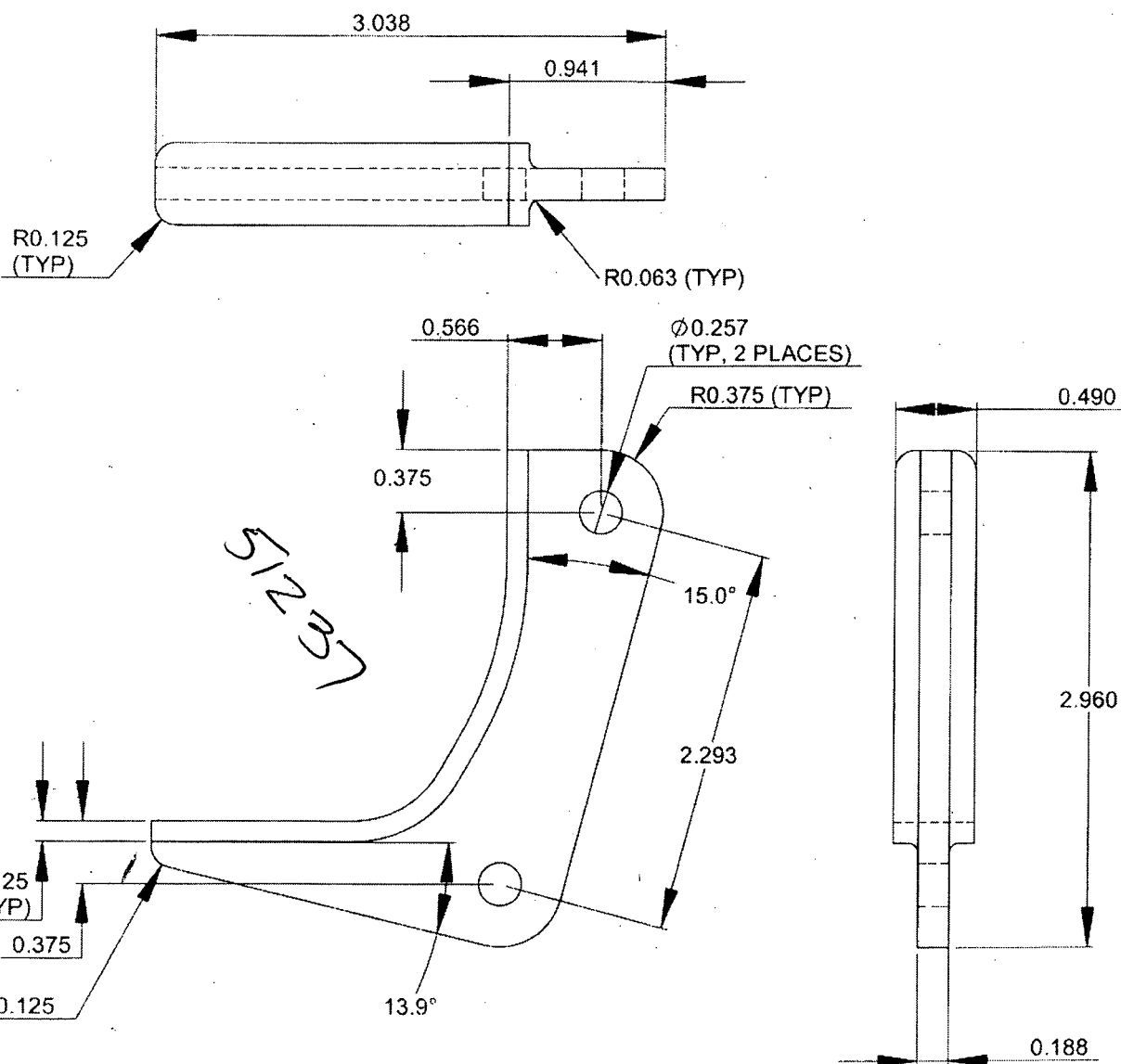
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3063	REV. A SHEET 1 OF 1
DATE	02.09.10	TITLE SUPPORT	SCALE 1:1
A	02.09.10	NEW ISSUE	



#### D3063-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3063-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)  
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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